

CLAIMS

1. A cylindrical battery comprising:

an electrode group formed from battery electrode plates of a positive
5 electrode and a negative electrode spirally wound with a separator interposed
therebetween; and

a cylindrical battery case for housing said electrode group;

at least one of the battery electrode plates being manufactured by a
method comprising:

10 an active material impregnation step for impregnating an entire porous
core substrate shaped like a thin plate with an active material;

a pressing step for performing press working on said active material
impregnated core substrate to form a plurality of rail shaped protrusions;

an active material removal step for removing the active material to form
15 core substrate exposed sections by applying ultrasonic vibrations to said rail
shaped protrusions;

a flattening step for compressing said core substrate exposed sections
down to an identical level with other sections; and

a cutting step for cutting predetermined sections including said core
20 substrate exposed sections to form a battery electrode plate.

2. A cylindrical battery according to claim 1, in which the positive and the negative electrode plates are manufactured by said method.